

Work Order ID 130431

130431

Page 1

Wednesday, March 11, 2015 9:17:01 AM

Item ID: D4857-M Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wiper Deflector
 Start Date: 3/27/2015 Start Qty: 8.00 *g* Cust Item ID:
 Required Date: 3/27/2015 Req'd Qty: 8.00 *g* Customer:
 Reference:

Approvals: Process Plan: CZ Date: 15/03/11 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4857	E								

100 0.00

100

Purchasing

Purchasing

Memo

Issue P/O: 27738
 Possible supplier: CARBON BY DESIGN
 Manufacture as per dwg D4857-M
 Prime Deflector as per dwg (SEE NOTE 4)
 Certificate of Conformity release note is required.

0.00

CZ 15/03/11 (8)

110 Receive & Inspect for Damage & Mat'l Certs 0.00

110

Packaging

Packaging

Memo

0.00

8x 8015-0413

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120	QC5- Inspect part completeness to step on W/O	0.00							
120						(8)			DAS 38 9-89
QC	Memo	0.00							
Quality Control									

APR 14 2015

130	Identify as per dwg & Stock Location: CCK065	0.00							
130									
Packaging	Memo	0.00							DAS 06 9-89
Packaging									

APR 14 2015

140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MCS 1504-16

CMF 15-4-15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Wednesday, March 11, 2015 9:17:01 AM

Page 1

Work Order ID: 130431

130431

Parent Item: D4857-M

D4857-M

Parent Item Name: Wiper Deflector

Start Date: 3/27/2015

Required Date: 3/27/2015

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 14.05.21 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4857-P *D4857-P* Wiper Deflector		Purchased	No				Each	0.0000					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

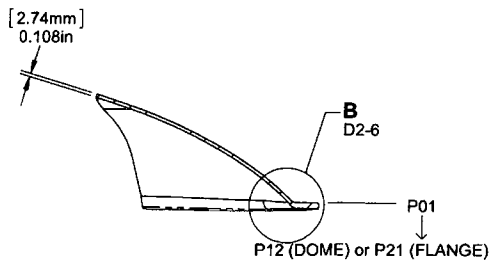
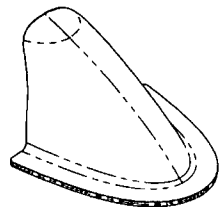
Work Order update only ☐

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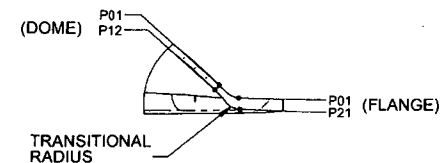
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Doc/Data									
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Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

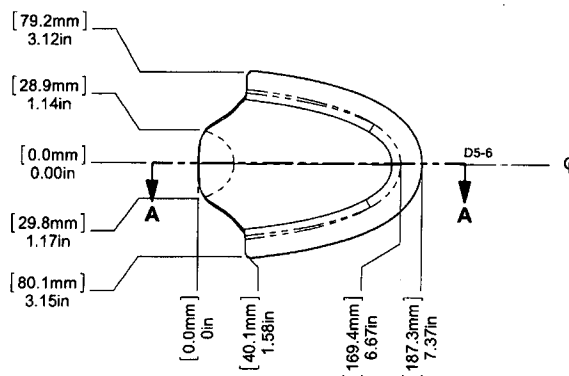
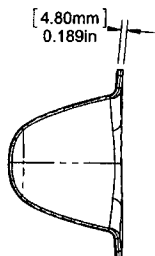
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SECTION A-A
B5-6



DETAIL B
D5-6



D4857-M WIPER DEFLECTOR

CD18/03/11
W10.130431

RELEASED
2014-06-19

NOTES:

- 1) MATERIAL: KEVLAR #285/353 4H SATIN, EPOXY PREPREG, 250°F CURE, 40% R/C
- 2) MATERIAL: CARBON FIBER PREPREG, ALDILA PREPREG SYSTEM 3K2X2-FR250-204/40 T300,
- 3) MATERIAL: ALDILA #120 E-GLASS AR250 WITH 48% RC;
- 4) FINISH: PRIMER IAW MIL-P-85582, 2-7 MIL MAX,
- 5) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) UNITS: INCHES UNLESS OTHERWISE NOTED, ALL METRIC DIMENSIONS ARE REFERENCE DIMENSIONS.
- 7) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 8) IDENTIFICATION: N/A
- 9) WEIGHT: 0.24 lbs (0.11 kg)
- 10) PART DIMENSIONS CONTROLLED BY CAD MODEL FILE D4857-M-e.IGES
- 11) SEE PAGE 7 FOR LAYUP SCHEDULE. MANUFACTURE IAW MPP 145. CURE 250°F FOR 4 HOURS.

APPROVED

DESIGN	DW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. E
MFG. APPR.	JFS	D4857	SHEET 6 OF 7
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	WIPER DEFLECTOR	NTS
DATE	14.06.05	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

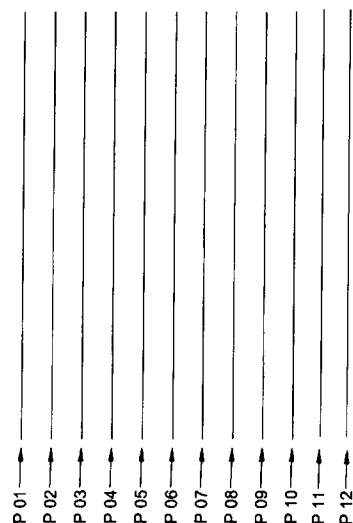
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Training									
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FAULT CATEGORY

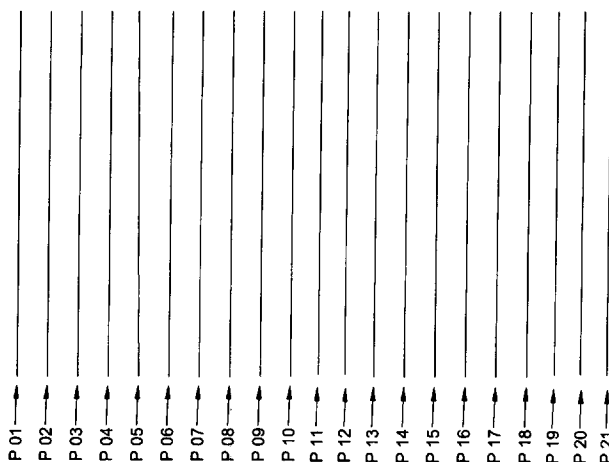
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8 7 6 5 4 3 2 1



LAYUP OF LAYERS (DOME)

LAMINATE - .108in (12 LAYERS)			
PLY	WARP ANGLE	MATERIAL	THICKNESS
01	90	①	.008-.010
02	0	①	.008-.010
03	90	②	.008-.010
04	0	②	.008-.010
05	90	②	.008-.010
06	0	②	.008-.010
07	90	②	.008-.010
08	0	②	.008-.010
09	90	②	.008-.010
10	0	②	.008-.010
11	90	②	.008-.010
12	0	②	.008-.010



LAYUP OF LAYERS (FLANGE)

LAMINATE - .189in (21 LAYERS)			
PLY	WARP ANGLE	MATERIAL	THICKNESS
01	90	①	.008-.010
02	0	①	.008-.010
03	90	②	.008-.010
04	0	②	.008-.010
05	90	②	.008-.010
06	0	②	.008-.010
07	90	②	.008-.010
08	0	②	.008-.010
09	90	②	.008-.010
10	0	②	.008-.010
11	90	②	.008-.010
12	0	②	.008-.010
13	90	②	.008-.010
14	0	②	.008-.010
15	90	②	.008-.010
16	0	②	.008-.010
17	90	②	.008-.010
18	0	②	.008-.010
19	90	②	.008-.010
20	0	②	.008-.010
21	90	③	.005

APPROVED

DESIGN	DW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. E
MFG. APPR.	JFS	D4857	SHEET 7 OF 7
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RELEASED
2014-06-11

8 7 6 5 4 3 2 1



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO27738**

Purchase Order Date 3/11/2015

PO Print Date 3/11/2015

Page Number 1 of 2

Order From :

VU-CBD001

Ship To : DART AEROSPACE LTD

CARBON BY DESIGN
4128 AVENIDA DE LA PLATA
OCEANSIDE, CALIFORNIA 92056
USA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 760-643-1300

Ship To Contact

Ship To Phone

Ship Via: FedEx PI ppd

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency USD

FOB FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D4857-P AS PER DWG D4857 REV. E B130431	Wiper Deflector	3/27/2015 Yes 3/27/2015	FN	8.00 Each	\$695.00	\$5,560.00

8P15-04-13

Line Total: \$5,560.00

2	71401-45	PROCUREMENT QUALITY CLAUSES	3/27/2015 No 3/27/2015		1.00	\$0.00	\$0.00
Procurement Quality Clauses A004 faa-pma/tso A005 right of entry A016 personnel qualification A025 certification of conformance A040 notification of quality escape A041 quality management A042 dart noyification by supplier A043 retention of quality documents							

PO Instructions: Fedex Acc#151793240

Note:

3/11/2015



carbon by design

4128 Avenida De La Plata - Oceanside, CA 92056
Phone: 760-643-1300 Fax: 760-643-1333
www.carbonbydesign.com

Packaging List

Date: 4/8/2015
Packaging List No. 17995
Cage Code: 4DG17
CBD Work Order No. 8615
Customer PO No.: PO27738

Billing Address:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Fed-Ex #151793240

Please Deliver To:

Dart Aerospace LTD
1270 Aberdeen
Hawkesbury, ON K6A 1K7
Canada

Customer Phone	Terms	Rep	Ship Date	Ship Via
613-632-5200	Net 30	JB	4/8/2015	FedEx 2nd Day

Item	Line #	Description	Qty	U/M
120.4084	1	Dart Aerospace D4857-M, Wiper Deflector S/N: 17995-1/17995-8 Procurement Quality Clauses <i>SP5-01-13</i>	8	ea

Thank you for your business.

Total Items: 8

SHIPPING VALUE
\$5,560.00

CERTIFICATE OF CONFORMANCE (SHORT FORM CUSTOMERS ONLY)

I certify that on _____, the Carbon by Design LP furnished the supplies or services called for by the Purchase Order Above via Delivery in accordance with all applicable requirements.

I further certify that the supplies or services are of the quality specified and conform in all respects with the contract requirements, including specifications, drawings, preservation, packaging, packing, marking requirements, and physical item identification, and are in the quantity shown in this or on the attached acceptance document.

Quality: _____ Date: _____

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carbon by design

4128 Avenida De La Plata, Oceanside, CA 92056
Phone: 760-643-1300 Fax: 760-643-1333

www.carbonbydesign.com

Invoice

Date: 4/8/2015

Invoice # 17995

PO. No.: PO27738

Sales Order#: 8615

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Fed-Ex #151793240

Please Ship To:

Dart Aerospace LTD
1270 Aberdeen
Hawkesbury, ON K6A 1K7
Canada

Customer Phone	Terms	Rep	Ship Date	Ship Via	Account Status
613-632-5200	Net 30	JB	4/8/2015	FedEx 2nd...	lz

Item	Line #	Qty	Description	U/M	Unit Price	Amount
120.4084	1	8	Dart Aerospace D4857-M, Wiper Deflector S/N: 17995-1/17995-8	ea	695.00	5,560.00
			Procurement Quality Clauses			0.00

SP15-01-B

Thank you for your business.

Total

\$5,560.00

All returns must be accompanied by a RMA #. Please call customer service at 760-643-1300 to receive a RMA number. Products damaged in shipment must be immediately documented and brought to the attention of Carbon by Design. Any products which have been installed/used are not subject to return. All returned Items, unless built to print, are subject to a 25% restocking fee. Canadian Customers are responsible for all brokerage fees, any fees not paid by the customer at the time of delivery are subject to further charges. No returns are accepted after 30 days.

WARNING -This document and its attachments may contain technical data, export of which is restricted by the International Traffic in Arms Regulations (ITAR) or the Export Administration Act (EAA) of 1979, as amended. Disclosure to foreign persons without prior U.S. Government approval is prohibited. Violations of these export laws and regulations are subject to severe civil and criminal penalties.

**carbon by design**

4/8/2015

CERTIFICATE OF CONFORMANCE

PO: No.: PO27738	DESC: Dart Wiper Deflector	Insp: DR	Packing #: 17995
Program: Dart	Drawing: D4857-M Rev E	Qty : 8	Serials: 17995-1/17995-8

Work Requirements:

Statement of Work:	No SOW on file
Internal Process Doc.:	APD: 2206-253
Inspection Document:	2206-253
Manufacturing Process:	Prepreg- Trapped Rubber
Security Requirement:	Confidential

Approved Non-Conformances: NO**Pending SDR/ECN:** NO**DISPOSITION:** To Customer, Ship**SHIP METHOD:** FedEx 2nd Day

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Certification Statement:

Carbon by Design LP certifies the items listed above conform to all of the applicable work and quality standard required in the purchase order listed above and any additional work requirements referenced.

All in process quality standards have been met according to customer requirements and Carbon by Design internal quality and finish requirements. All materials Certification are available for inspection and will remain on file at Carbon by Design for a period of no less than ten years.

Finished Materials/Process Specifications:

Per Drawing Requirements

Additional Quality Clauses:

Per PO Requirements, 100% Inspection

Active Quality Systems:

ISO9001:2008

Signature: Daniel RodriguezInspector's Name: David RodriguezTitle: QCDate: 4/8/15